Date: Thursday, 1/25/2007 10:24:57 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 30466B
Estimate Number : 10378
P.O. Number : N/A
This Issue : 1/25/2007 **S.O. No.** : N/A
Prsht Rev. : NC
First Issue : N/A **Type** : SMALL /MED FAB
Previous Run : 29978B
Written By : JW
Checked & Approved By : 07.01.25
Comment : Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF
Est Rev:D Now on Water Jet 06-04-11 JLM

Drawing Name : STEP SPACER
Part Number : D30653
Drawing Number : D3065 REV. B
Project Number : N/A
Drawing Revision : B
Material : N/A
Due Date : 2/15/2007 **Qty:** 60 **Um:** Each

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet

Comment: Qty.: 0.2287 sf(s)/Unit Total : 13.7214 sf(s)
Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch: M103321 (50) M102448 (2)

2.0	WATER JET	FLOW WATER JET

Comment: FLOW WATER JET
1-Cut as per Dwg D
Dwg Rev: B
Prog Rev: B

2-Deburr if necessary

SAD 07/02/10 (PTO)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE SAD ~~07/10~~ 07/02/10

4.0	QC8	SECOND CHECK

Comment: SECOND CHECK MF 07/02/12 (60)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr Stack

MF 07-02-13 (60)

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** ☐ **Date:** 07/03/19

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			
07/02/12	2.0	Holes 0.128" was to big. Set offset was too wide	05/04/12	SCRAP and replace Qty (1)	SAM 07/02/12	07/02/12	[illegible]	07/02/12

NOTE: Date & initial all entries

Date: Thursday, 1/25/2007 10:24:58 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** STEP SPACER

Job Number: 30466B **Part Number:** D30653

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	BRAKE NC	NC BRAKE
	Comment: NC BRAKE Bend as per Dwg D3065	SB 07/02/23 (60)
7.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	JOTS-14
8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	60X M-L 07/03/14
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT CHEMICAL CONVERSION COAT	07/03/14 60
10.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location:_____	07/03/14 60
11.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	(60) 07/03/14

Job Completion

07/07/16

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30466B
Description: Step Spacer	Part Number:	D3065-3
Inspection Dwg: D3065 **Rev:** B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.260	+/-0.010					
3.260	+/-0.010					
5.260	+/-0.010					
6.520	+/-0.010					
2.093	+/-0.010					
3.936	+/-0.010					
4.186	+/-0.010					
Ø0.128	+0.005/-0.000					
Ø1.250	+0.005/-0.000					
Pitch 1.204	+/-0.005					

Measured by:	
Date:	

Audited by:	
Date:	

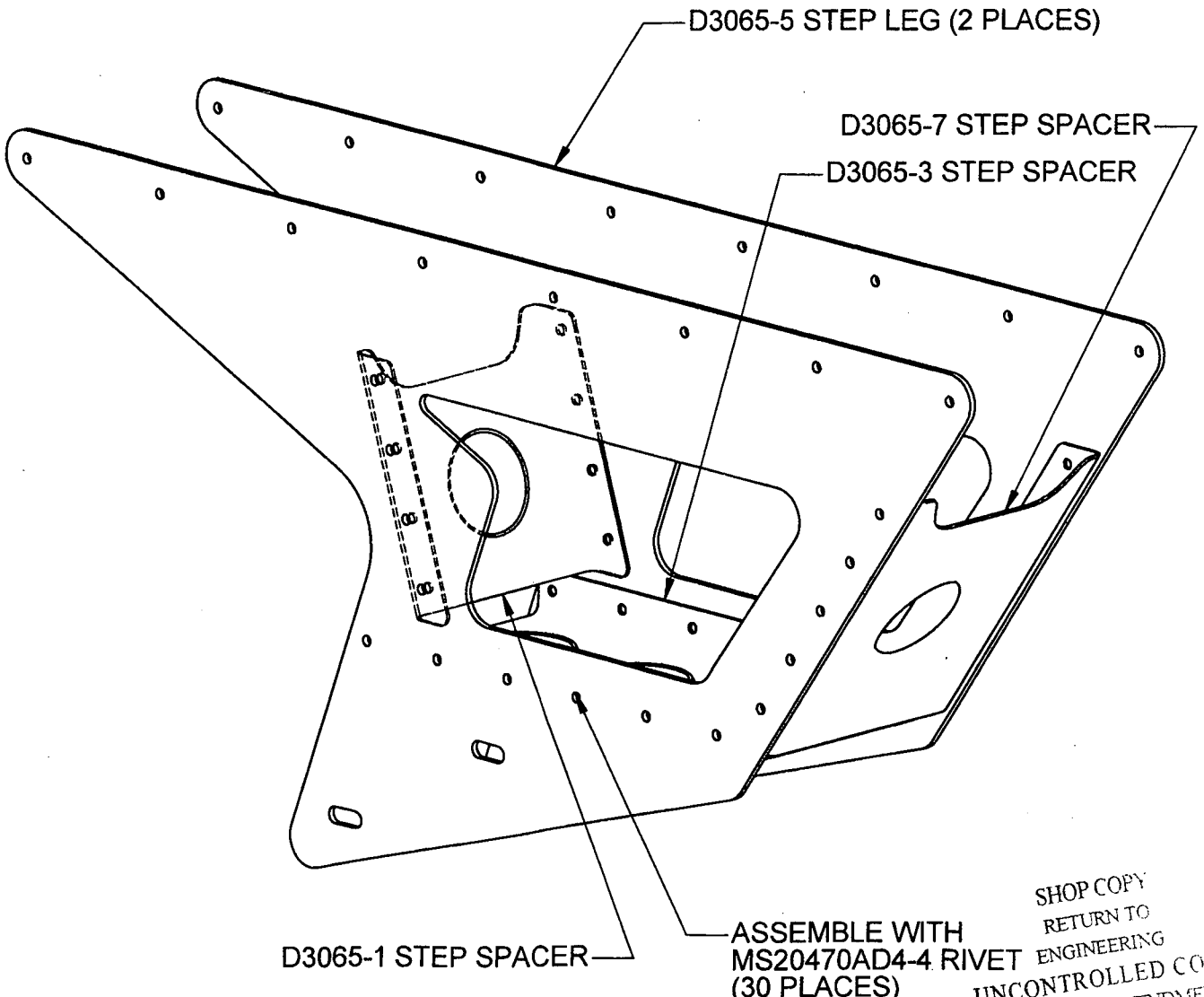
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue P/O D3065-041	KJ/RF	
B	04.08.12	Removed dimension 1.204	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	

DESIGN GP	DRAWN BY CB	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2

A	02.09.11	NEW ISSUE
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5

RELEASED
06 06 20



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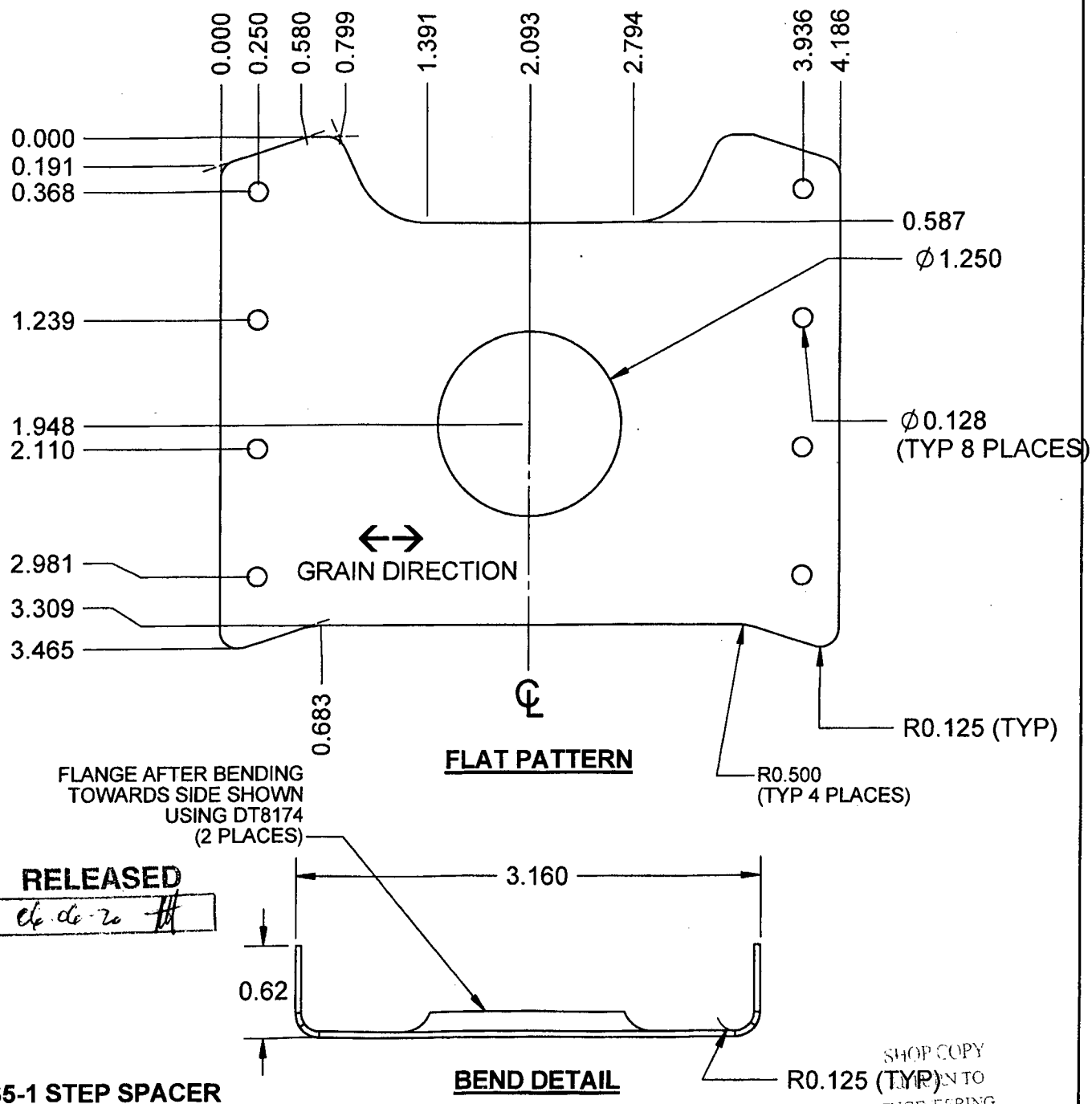
WORK ORDER NO. 30466B

D3065-041 STEP LEG ASSEMBLY

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



RELEASED
06-06-23

D3065-1 STEP SPACER

1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
3) BREAK ALL SHARP EDGES 0.005 TO 0.010
4) PART IS SYMMETRIC ABOUT CENTERLINE
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER NO. 30466B

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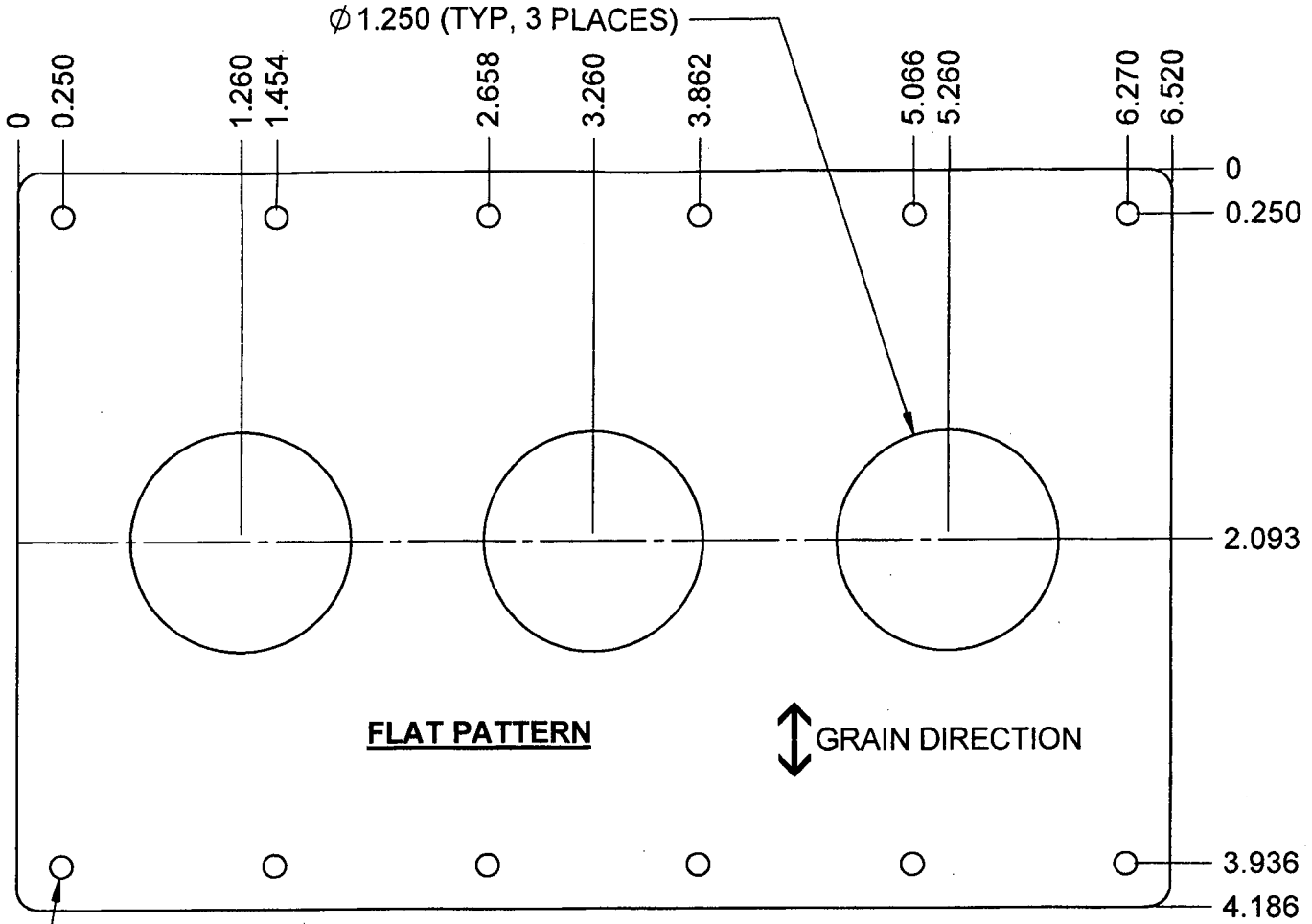
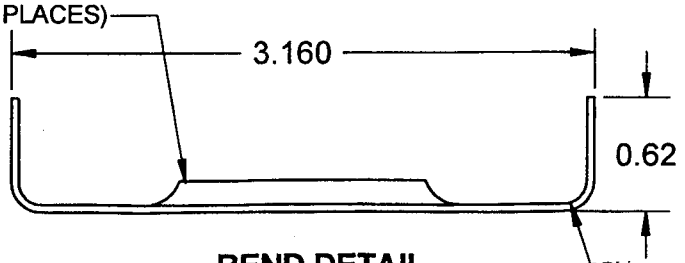
CHECKED PH	APPROVED	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



Ø0.129 (TYP, 12 PLACES)

FLANGE AFTER TOWARDS SIDE SHOWN USING DT8174 (3 PLACES)



BEND DETAIL

RELEASED
Oct 20

D3065-3 STEP SPACER

1) MATERIAL: 2024-T3 (QQ-A-250/4)
   0.040 THICK (REF DART SPEC. M2024T3S.040)
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
3) PART IS SYMMETRIC ABOUT CENTERLINE
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

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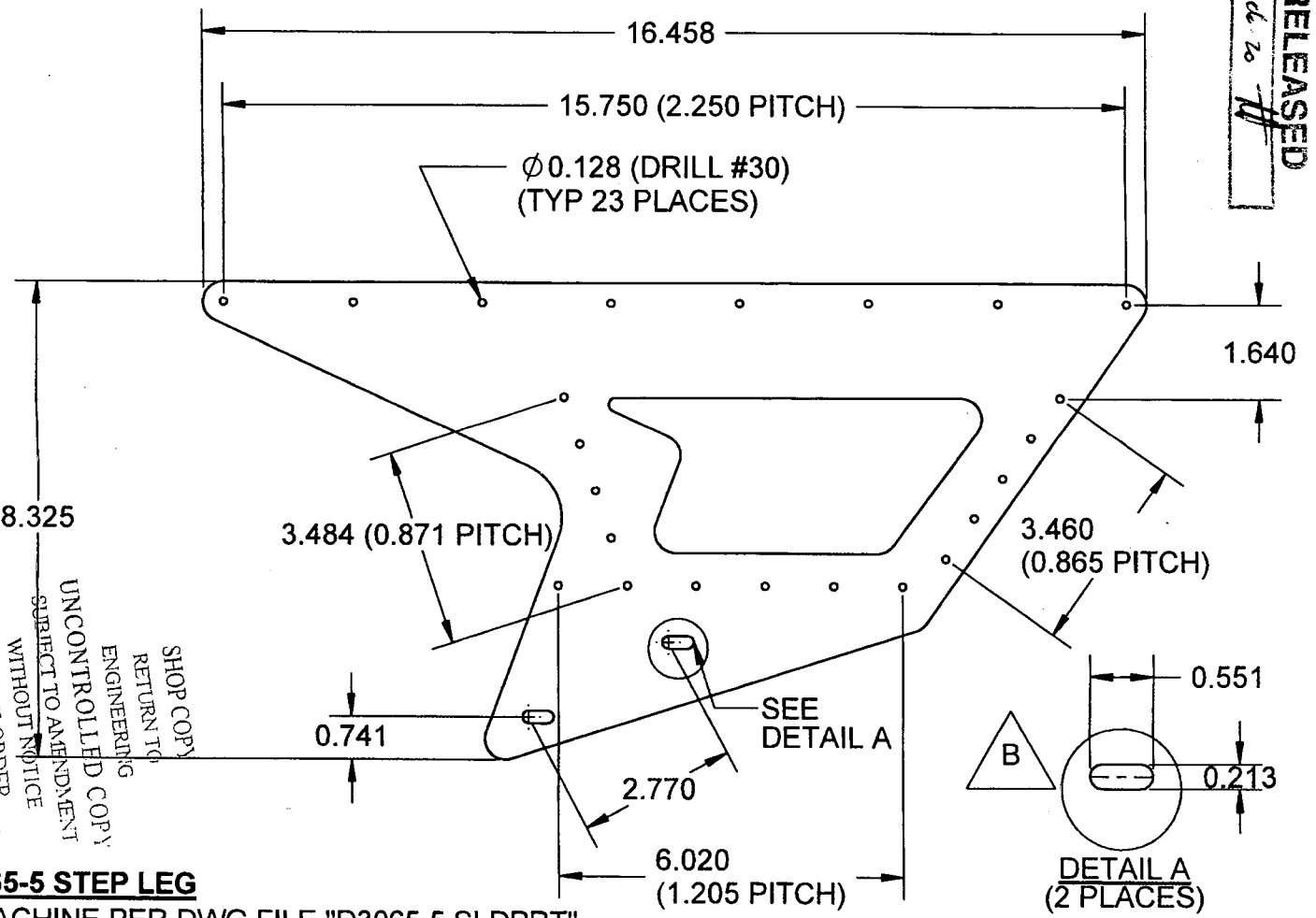
WORK ORDER
NO. 304166B



RELEASED
16.06.20

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WITHOUT NOTICE

WORK ORDER
NO. 30416B

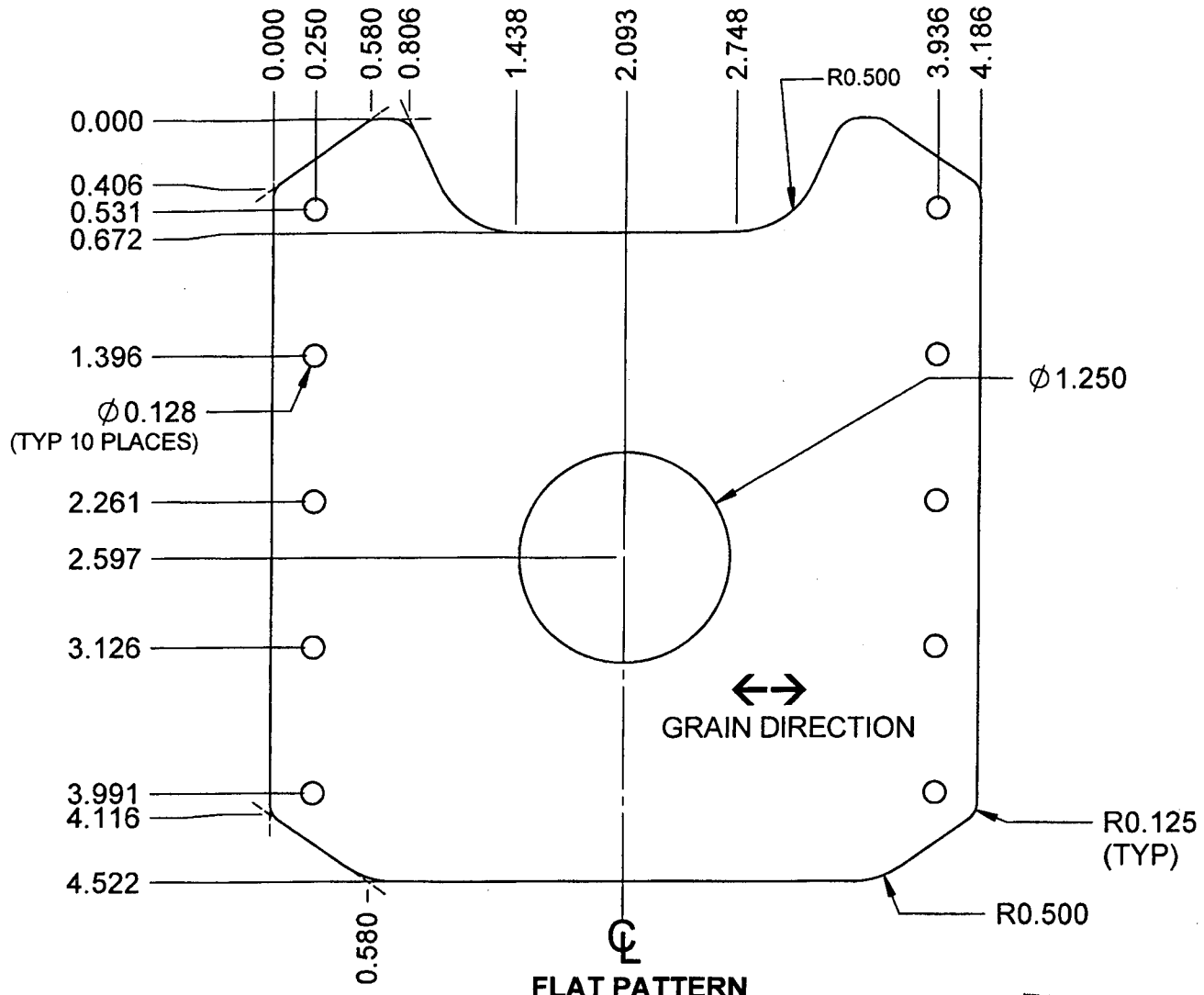
D3065-5 STEP LEG

1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

DART

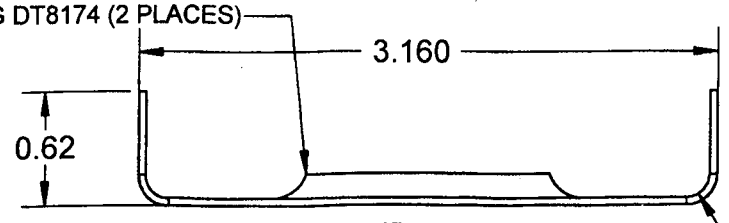
DESIGN	DRAWN BY	DART AEROSPACE LTD
– GP	C.B	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	REV. B
PH		SHEET 4 OF 5
DATE	DRAWING NO.	SCALE
06.05.23	D3065	1:3
	TITLE	
	STEP LEG ASSEMBLY	

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



FLAT PATTERN

FLANGE AFTER BENDING TOWARDS SIDE SHOWN USING DT8174 (2 PLACES)



BEND DETAIL

RELEASED
06 06 23

D3065-7 STEP SPACER

1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
3) PART IS SYMMETRIC ABOUT CENTERLINE
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER NO 304666B

DART AEROSPACE LTD	Work Order:	30466B
Description:	Part Number:	D3065-3
Inspection Dwg: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [X] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/- 0.010	0.252	✓		Vern	
2.093	+/- 0.010	2.099	✓		Vern	
3.936	+/- 0.010	3.940	✓		Vern	
4.186	+/- 0.010	4.195	✓		Vern	
0.250	+/- 0.010	0.254	✓		Vern	
1.260	+/- 0.010	1.267	✓		Vern	
1.454	+/- 0.010	1.457	✓		Vern	
2.658	+/- 0.010	2.663	✓		Vern	
3.260	+/- 0.010	3.267	✓		Vern	
3.862	+/- 0.010	3.864	✓		Vern	
5.066	+/- 0.010	5.060	✓		Vern	
5.260	+/- 0.010	5.265	✓		Vern	
6.270	+/- 0.010	6.277	✓		Vern	
6.520	+/- 0.010	6.527	✓		Vern	
Ø1.250	+0.012 / -0.001	1.250	✓		Vern	
Ø0.129	+0.005 / -0.001	0.131	✓		Vern	
0.040	+/- 0.010	0.040	✓		Vern	

Measured by:	SAD
Date:	07/02/10

Audited by:	J.F.
Date:	07/02/10

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	